

Work Order ID 83429

April-18-12 8:13:38 AM

83429

Page 1

Item ID: D2564

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Angle

Start Date: 18/04/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2564	Rev B1								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)								
				<u>12-5-02</u>		<u>24</u>			
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA276 Rev: _____ & Dwg D2564 Rev: _____ 2- Deburr if necessary								
	<u>Manual</u>			<u>12-5-07</u>		<u>24</u>			
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control				<u>12-5-08</u>		<u>24</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Mounting Angle

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12/08/05

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location

0.00

ST23

140

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

24

12-5-10

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/5/10

MUF
12-05-10

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Picklist Print

April-18-12 8:13:43 AM

Page 1

Work Order ID: 83429

83429

Parent Item: D2564

D2564

Parent Item Name: Mounting Angle

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: D02.09.09Re-format; Added FA276 FolioKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207		Manufactured	No			100	f	18.3340	0.0916	2.314105			

D6207

Angle Extrusion

**

Location

MAT028

72237

Loc Qty

18.334

18.334

Loc Code

M 606 IT 6 A 1.000 W. 125 / ~~10~~
12-5-10

115776

2.5f

~~10~~ 12-5-02

W/O:		WORK ORDER CHANGES					
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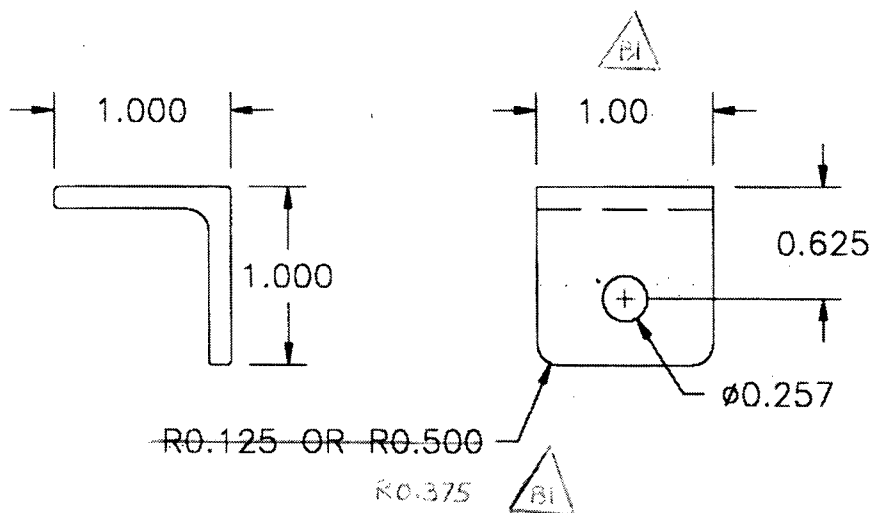
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DESIGN	DRAWN BY	DART AEROSPACE LTD	
MIKE M	MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	BW	D2564	SHEET 1 OF 1
DATE	TITLE		SCALE
96:04:30	MOUNTING ANGLE		1:1
B	97:05:06	MODIFIED DIMENSIONS	
BI	DATE 07.17	R0.375 WAS R0.125 OR R0.500 1.00 WAS 1.000	

RELEASED
97/05/06 BW



NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 ± 0.015
- 3) TOLERANCES PER DART 651 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83429 MLC
12/04/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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